

Work Order ID 83648

83648

Page 1

April 23 12 10:08:06 AM

Item ID: D350-636-011

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Skidtube LH

Start Date: 23/04/2012 Start Qty: 1.00

1

Cust Item ID:

Required Date: 07/05/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: MLJ

Date: 12/04/23 Tooling:

Date:

Run Start *NR1*

QC:

Date: SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
----------	--------------

D2750	F
-------	---

D3492	C
-------	---

0.00

100

100

DOCUMENT CONTROL

DC

0.00

Memo

Document Control

Photocopy blue file and type labels per PPP D350-636-011 CHG 006

8/2/04/23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 83648

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Item ID: D350-636-011

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N900040100Setup Start ***NS1***

Revision ID:

Item Name: Skidtube LH

Stop ***NS2***

Start Date: 23/04/2012 Start Qty: 1.00

1

Cust Item ID:

Required Date: 07/05/2012 Req'd Qty: 1.00

1

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Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

110

0.00

110

Skidtubes

0.00

Skidtubes

Memo

Skidtubes

1- Pick D2600-3 Bent ✓

2- Deburr FWD and AFT ends, remove bending marks. Scribe batch# inside AFT end per dwg D2750 ✓

3- Drill pilot holes for blade fitting bolt holes using DT8983. Open to 0.500", deburr. ✓

4- Locate DT8330 off of blade fitting bolt holes and drill pilot holes for blade fitting ✓

5- Drill only two fwd step holes using DT9616. Ensure proper positioning. ✓

6- Drill pilot holes as per Dwg D2750 sheet 4 (D2750-1 details). Drill using drill Jig DT8150 & DT8863A for first side only DT8863B for second side (detail B) ✓

7- Clecko DT8863B on second side of tube and drill pilot holes for detail B. ***SECOND SIDE*** ✓

8- Open up holes for Detail B to 0.375" (4 holes per side) and blade fitting location holes to 0.500" (total of 4 holes per side) as per dwg D2750. Open up holes for ground handling and detail C to 0.500" (8 holes per side) ✓

9- Drill pilot holes for wearplates as per Dwg D2750 using DT8108 open to 0.297". ✓

10- Open up holes of Detail A to 0.297" (total of 2 holes per side) ✓

920 12-04-30

W/O:		WORK ORDER CHANGES					
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Stop ***NS2***

Start Date: 23/04/2012 **Start Qty:** 1.00 ***1***

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Required Date: 07/05/2012 **Req'd Qty:** 1.00 *** 1 ***

Customer:

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

11-Weld D2744 Cap as per Dwg D2750 and QSI 004. Fill grooves in bend left from bending as per QSI 004

A/R Aluminum Rod batch: M120829 06 16/09/30

12-Grind welds flush as per Dwg D2750

QC10- Inspect visual per QSI004- ground welds	0.00
---	------

120

QC

Memo

0.00

Quality Control

QC5- Inspect part completeness to step on W/O	0.00
---	------

130

QC

Memo

0.00

W/O:		WORK ORDER CHANGES					
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Required Date: 07/05/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

140

Chemical Conversion Coat per QSI005 4.1

0.00

140

HandFinish

Memo

0.00

Hand Finishing

MG 12-5-2

150

QC7-Inspect Chemical Conversion Coat

0.00

150

QC

Memo

0.00

Quality Control

1 Ø 3E12-05-03

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***
Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160		0.00							
160	Skidtubes								
Skidtubes	Memo	0.00							
Skidtubes	1-Open up holes of Detail C and ground handling to 0.625" (total of 8 holes per side) as per dwg D2750.								
	2-Open up holes of Detail B to 0.750" (total of 4 holes per side) as per dwg D2750.								
	3- Open float hole to 0.500" (4 per side)								
	4-Chamfer holes of Detail B, C, ground handling and float holes per dwg D2750 (welding instructions on sheet 8)								
	5-Deburr and blow out all chips from inside of tube								
	6- Prepare tube for welding, remove alodine as required.								
	7-Bond web D2739 in place as per QSI 015 A/R Sikaflex-291 batch: <u>121221</u> exp. date: <u>13/01/04</u>								
	8- Weld spacers D3490-1, D3490-3 and D2743 as per dwg D2750 & QSI004 (welding instructions on sheet 8) A/R Aluminum Rod batch: <u>M120854</u>								
	9- At section AJ-AJ drill out x-bolt spacer to 0.404"								
	10-Grind welds flush as per Dwg D2750								

DC 12/05/03

- DC 12/05/03

> 86 12/05/07

- DC/CC 17-5-8

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NS2

Start Date: 23/04/2012 Start Qty: 1.00

1

Cust Item ID:

Required Date: 07/05/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

NR1

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
	11-Spot face ground handling holes section (total of 4 places per side) as per dwg D2750								
	12-Deburr holes								
170	QC10- Inspect visual per QSI004- ground welds	0.00							
170									
QC	Memo	0.00							
Quality Control									
180	QC5- Inspect part completeness to step on W/O	0.00							
180									
QC	Memo	0.00							
Quality Control									

*SA/CL 12-5-8**8/2/12/09**8/2/12/09**(H)*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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N900040100Setup Start ***NS1***

Revision ID:

Item Name: Skidtube LH

Stop ***NS2***

Start Date: 23/04/2012 Start Qty: 1.00

1

Cust Item ID:

Required Date: 07/05/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190	Pressure Wash per QSI005 4.3	0.00				1X	Ø		m-l 12/05/09
190									
HandFinish	Memo	0.00							
Hand Finishing	Re-alodine tube as per QSI 005 section 4.1.2.1 do not acid etch.								
200	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00				1X	Ø		m-l 12/05/10
200									
Powdercoat	Memo	0.00							
Powder Coating	START TIME: 7:145								
	OVEN TEMPERATURE: 320 °F								
	FINISH TIME: 8:15								
210	QC3- Inspect Part Finish	0.00				1	Ø		DL 12-5-11
210									
QC	Memo	0.00							
Quality Control	Inspect for foreign object per QSI 024								

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Item ID: D350-636-011

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Skidtube LH

Stop

NS2

Start Date: 23/04/2012 Start Qty: 1.00

1

Cust Item ID:

Required Date: 07/05/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
220	HandFinishing	0.00							
220	HandFinish	0.00				1	2	(2P)	12/05/14
Hand Finishing	Memo 1- Install inserts as per Dwg D2750					LH			Pto →
230	HandFinishing	0.00							
230	HandFinish	0.00				1 LH	2	(2P)	12/06/20
Hand Finishing	Memo 1-Inspect for Foreign Objects 2-Spray inside of tube with "LPS-3" batch: <u>N/A</u> 3-Install blade fitting D3488-041, wearshoes and ground handling hardware as per dwg D2750 SIKA FLEX 241 BATCH: <u>121409</u> EXP DATE: <u>13/03</u> 4-assemble o'ring to plug as per dwg D3492 and apply o'ring lube A/R 55-o'ring lube batch: <u>110348</u> 5-Coat all exposed fasteners with "LPS Procyon" batch: <u>117596</u>								

W/O: 83648		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D350-636-011 PAR #: _____ Fault Category: Skid Tube NCR: Yes No DQA: Aut Date: 12/07/04
 Resolution: _____ Disposition: Re-work QA: N/C Closed: ✓ Date: 12/7/5

NCR: 12/15/04		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
12/06/03	# 230	Found that Production D3486-041/42 Do not fit skid tube. P.C. Tol on Blade (D3486-041/42 + Hammer Drill (Process.	GP 12-06-04	Drill all ^{At} Saddle + aft hls. to max tol. Drill hls in Blade D3486-041/42 to max tol.	GP 12-6-6	S. J. Keefe 12/06/04	GP 12-06-04	S 12/06/03
			GP 12-06-04	touch up hls with alodine as per AS2004 AND Reassemble.	GP 12/06/20	S. J. Keefe 12/06/04	GP 12-06-04	S 12/06/03

NOTE: Date & initial all entries

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N900040100Setup Start ***NS1***

Revision ID:

Item Name: Skidtube LH

Stop ***NS2***

Start Date: 23/04/2012 Start Qty: 1.00

1

Cust Item ID:

Required Date: 07/05/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
240	QC5- Inspect part completeness to step on W/O	0.00							
240									
QC	Memo	0.00							
Quality Control									
250	Pick Kit	0.00							
250									
Packaging	Memo	0.00							
Packaging									
260	QC4- 100% Inspect kits for completeness	0.00							
260									
QC	Memo	0.00							
Quality Control	*****ensure antiseize is on AN8C21A bolts*****								

W/O:		WORK ORDER CHANGES					
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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
270		0.00							
270	Packaging								
Packaging	Memo	0.00							
Packaging	Package as per PPP D350-636-011								
280	QC21- Final Inspection - Work Order Release	0.00							
280									
QC	Memo	0.00							
Quality Control									

Rev I

1X

12/6/12

12/6/28

ME
12-06-27

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Picklist Print

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Page 1

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Parent Item: D350-636-011

D350-636-011

Parent Item Name: Skidtube LH

Start Date: 23/04/2012

Required Date: 07/05/2012

Start Qty: 1.00

Required Qty: 1.00

Comments:

IPP Rev:I 02.09.25 Rearranged procedure steps KJ
 IPP Rev:J 06-03-23 As per Rev D JLM
 IPP Rev:K 06-07.13 As per dsi9343 EC
 IPP Rev:L 07-07-28 Added SS Wearplates(Rev E) JLM Verf:EC
 IPP Rev:M 08-04-22 update steps 4, 13 DD verified by:ec
 IPP Rev:N 08-09-23 revF as per dwg DD verified by:ec
 IPP Rev:O 09-02-06 apply antiseize on AN8C21A bolts as per PAR09-010
 DD verf:EC
 seq110 DD verf:EC
 DD verf:EC
 IPP Rev:P 10.06.22 revise
 IPP Rev:Q 10.10.01 as per IIN revH

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D3492-1		Manufactured	No			230	Each	221.0000	8	8			
D3492-1									**	8	(2P)	12/05/15	
Plug													

Location	Loc Qty	Loc Code
FP002 83259	14	
69531	8	
74444	2	
76235	4	
FP-A	207	
81963	7	
83098 ✓	200	

D3492-3		Manufactured	No			230	Each	189.0000	8	8			
D3492-3									**	8	(2P)	12/05/15	
Plug													

Location	Loc Qty	Loc Code
FP-A	189	
81967	5	
83099 ✓	184	

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Parent Item Name: Skidtube LH

83648

D350-636-011

Start Date: 23/04/2012

Required Date: 07/05/2012

Start Qty: 1.00

Required Qty: 1.00

NAS1611-010

Purchased

No

230

Each

247.0000

8

8

NAS1611-010

O-RING

**

8

20

12/05/15

Location

Loc Qty

Loc Code

FP001

121584

247

110915

14

117460

8

118077

1

118612

3

119438

47

120986

12

121166

12

121259

50

121415

100

NAS1149D0863J

Purchased

No

250

Each

179.0000

2

2

NAS1149D0863.I

WASHER

**

120308

Q

Location

Loc Qty

Loc Code

ST298

179

118078

34

119307

45

120308

100

D2744

Manufactured

No

110

Each

30.0000

1

1

D2744

Cap

**

8612/04/30

Location

Loc Qty

Loc Code

LG002

30

62715

1

70881

1

78900

28

April-23-12 10:08:10 AM

Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
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D350-636-011

Start Date: 23/04/2012

Required Date: 07/05/2012

Start Qty: 1.00

Required Qty: 1.00

D2600-3-BENT

Manufactured No

110

Each

30.0000

1

1

D2600-3-BENT

Extrusion Bent

**

① 1204-30

Location

Loc Qty

Loc Code

LG

30

66875

7

73253

1

75021

1

75022

1

75023

1

81330

4

82347

3

83305

12

D2743

Manufactured No

160

Each

233.0000

8

8

D2743

Crossbolt Spacer

**

BE 12/05/07
BB3262 18

Location

Loc Qty

Loc Code

LG

-51

81965

159

LG001

284

67766

4

68251

3

73403

64

74445

1

79517

2

D2739

Manufactured No

160

Each

3.0000

1

1

D2739

350 I Beam

**

12/05/03

Location B83448

Loc Qty

Loc Code

LG

3

72155

1

81508

1

82124

1

①

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Work Order ID: 83648

83648

Parent Item: D350-636-011

D350-636-011

Parent Item Name: Skidtube LH

Start Date: 23/04/2012

Required Date: 07/05/2012

Start Qty: 1.00

Required Qty: 1.00

D3490-3

Manufactured No

160

Each

46.0000

4

4

D3490-3

Cross Bolt Spacer

**

BE 12/05/07
B83313 x4

Location

Loc Qty

Loc Code

LG

44

82016

44

LG001

2

78800

2

D3490-1

Manufactured No

160

Each

64.0000

4

4

D3490-1

Cross Bolt Spacer

**

BE 12/05/07
B83269 x4

Location

Loc Qty

Loc Code

LG

55

81976

55

LG001

9

62450

2

74875

4

77042

3

ALS4-1032-225

Purchased No

220

Each

1,850.000

38

38

ALS4-1032-225

Insert

**

38

519 12/05/14

Location

Loc Qty

Loc Code

ST281

1827

108696

146

110768

62

118386

55

118966

68

121269 ✓

1496

ST282

23

120410

10

120451

13

* *

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Work Order ID: 83648

Parent Item: D350-636-011

Parent Item Name: Skidtube LH

83648

D350-636-011

Start Date: 23/04/2012

Required Date: 07/05/2012

Start Qty: 1.00

Required Qty: 1.00

D3793-3

Manufactured No

230 Each

17.0000 1 1

D3793-3

Wearshoe

**

1 (2P) 12/05/14



Location

Loc Qty

Loc Code

FP001

17

80434

6

82166 ✓

11

AN8C35A

Purchased No

230 Each

90.0000 1 1

AN8C35A

BOLT

**

1 (2P) 12/06/10

Location

Loc Qty

Loc Code

FP002

89

115960

1

118286 ✓

38

121275

50

ST346

1

114442

0

115188

0

115960

1

D3793-1

Manufactured No

230 Each

13.0000 1 1

D3793-1

Wearshoe

**

1 (2P) 12/05/14

Location

Loc Qty

Loc Code

FP001

13

83393 ✓

82171

13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Work Order ID: 83648

Parent Item: D350-636-011

Parent Item Name: Skidtube LH

83648

D350-636-011

Start Date: 23/04/2012

Required Date: 07/05/2012

Start Qty: 1.00

Required Qty: 1.00

D3488-041

Manufactured No

230

Each

3.0000

1

1

D3488-041

Blade Fitting Assembly, LH

**

1 (SP) 12/06/12

* *

Location

Loc Qty

Loc Code

FP002

83407 ✓

3

61689

1

75056

1

77021

1

D3794-3

Manufactured No

230

Each

10.0000

1

1

D3794-3

Gasket

**

1 (SP) 12/05/14

Location

Loc Qty

Loc Code

FP002

83396 ✓

10

74530

2

80436

8

AN6C44A

Purchased No

230

Each

168.0000

4

4

AN6C44A

BOLT

**

4 (SP) 12/05/14

Location

Loc Qty

Loc Code

FG

2

103964

2

ST343

166

120143

5

121013

11

121167 ✓

100

121440

50

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Work Order ID: 83648

83648

Parent Item: D350-636-011

D350-636-011

Parent Item Name: Skidtube LH

Start Date: 23/04/2012

Required Date: 07/05/2012

Start Qty: 1.00

Required Qty: 1.00

MS21083C8

Purchased

No

230

Each

110.0000

1

1

MS21083C8

NUT

**

1 (2P) 12/06/20

Location

Loc Qty

Loc Code

304

100

121185 ✓

50

121349

50

FP002

1

115884

1

ST303

4

115884

0

118077

1

119309

2

119638

1

ST304

5

121011

5

D3536-25

Manufactured

No

230

Each

9.0000

1

1

D3536-25

Gasket

**

1 (2P) 12/05/14

Location

Loc Qty

Loc Code

FP

9

81342

9

D3631-1

Manufactured

No

230

Each

115.0000

8

8

D3631-1

Washer

**

8 (2P) 12/05/14

Location

Loc Qty

Loc Code

FG

100

81874

100

ST072

83583 ✓

15

68062

2

75548

13

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Page 8

Work Order ID: 83648

83648

Parent Item: D350-636-011

D350-636-011

Parent Item Name: Skidtube LH

Start Date: 23/04/2012

Required Date: 07/05/2012

Start Qty: 1.00

Required Qty: 1.00

D3791-1 Manufactured No

230 Each

12.0000 1 1

D3791-1

Wearplate

**

1 (28) 12/05/14

Location

Loc Qty

Loc Code

FP002

83392 ✓

12

62239

2

82168

10

AN960C10L

* NAS1149C0332 ✓ Purchased

No

230 Each

0.0000 38 38

*AN960C10I *

washer

121509 ✓

**

38 (28) 12/05/14

D2745

Manufactured No

230 Each

36.0000 8 8

D2745

Bushing

**

8 (28) 12/05/14

Location

Loc Qty

Loc Code

FP

6

79518

6

FP001

30

69529

1

76142

1

81964

28

83260 ✓

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Page 9

Work Order ID: 83648

Parent Item: D350-636-011

Parent Item Name: Skidtube LH

83648

D350-636-011

Start Date: 23/04/2012

Required Date: 07/05/2012

Start Qty: 1.00

Required Qty: 1.00

AN3C5A

Purchased

No

230

Each

1,642.000

34

34

AN3C5A

Bolt

**

34

12/05/14

Location

Loc Qty

Loc Code

FP001

7

115835

7

ST350

1635

116419

28

117343

13

117764

7

117872

2

119749

23

120423

62

1210168

500

121255

500

121444 ✓

500

D3537-1

Manufactured

No

230

Each

17.0000

3

3

D3537-1

Wearpad

**

3

12/05/14

Location

Loc Qty

Loc Code

FG

10

79833

10

FP002

7

69817

5

73716

2

NAS1149C0832R

Purchased

No

230

Each

279.0000

1

1

NAS1149C0832R

WASHER

**

1

12/06/20

Location

Loc Qty

Loc Code

ST297

279

114915 ✓

279

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Shop Packet Print

Page 9

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Page 10

Work Order ID: 83648

Parent Item: D350-636-011

Parent Item Name: Skidtube LH

83648

D350-636-011

Start Date: 23/04/2012

Required Date: 07/05/2012

Start Qty: 1.00

Required Qty: 1.00

AN3C6A

Purchased

No

230

Each

425.0000

4

4

AN3C6A

BOLT

**

4

SP

12/05/14

Location

Loc Qty

Loc Code

FP001

1

111982

1

ST351

424

111982

2

116419

23

116549

2

116704

12

117619

10

117688

1

117872

5

118422

13

119449

21

120423

3

120693

332

NAS1611-013

Purchased

No

230

Each

154.0000

8

8

NAS1611-013

O-RING

**

8

SP

12/06/20

Location

Loc Qty

Loc Code

FP001

154

116582

5

117291

2

117887

53

119623

36

121166

8

121259

50

121584✓

121825✓

2

6

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Page 11

Work Order ID: 83648

Parent Item: D350-636-011

Parent Item Name: Skidtube LH

83648

D350-636-011

Start Date: 23/04/2012

Required Date: 07/05/2012

Start Qty: 1.00

Required Qty: 1.00

D3535-25

Manufactured No

230

Each

26.0000

1

1

D3535-25

Wearshoe

**

1

(20)

12/05/14

Location

Loc Qty

Loc Code

FP001

26

62233

1

81357

8

82156 ✓

17

D3794-1

Manufactured No

230

Each

26.0000

1

1

D3794-1

Gasket

**

1

(20)

12/05/14

Location

Loc Qty

Loc Code

FP

23

82167 ✓

23

FP002

3

75042

2

80435

1

MS21043-6

Purchased No

230

Each

710.0000

4

4

MS21043-6

NUT

**

4

(20)

12/05/14

Location

Loc Qty

Loc Code

FG

20

103693

20

ST301

690

117887

6

118384 ✓

184

120308

500

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Page 12

Work Order ID: 83648

83648

Parent Item: D350-636-011

D350-636-011

Parent Item Name: Skidtube LH

Start Date: 23/04/2012

Required Date: 07/05/2012

Start Qty: 1.00

Required Qty: 1.00

D3493-1

Manufactured No

250

Each

55.0000

2

2

**

83087

[Handwritten signature]

D3493-1

Washer

Location

Loc Qty

Loc Code

ST050

55

70697

2

77573

1

78835

11

82023

41

MS21083C8

Purchased

No

250

Each

110.0000

2

2

**

[Handwritten signature]

MS21083C8

NUT

Location

Loc Qty

Loc Code

304

100

121185

50

121349

50

FP002

1

115884

1

ST303

4

115884

0

118077

1

119309

2

119638

1

ST304

5

121011

5

1121349

[Handwritten signature]

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 83648

83648

Parent Item: D350-636-011

D350-636-011

Parent Item Name: Skidtube LH

Start Date: 23/04/2012

Required Date: 07/05/2012

Start Qty: 1.00

Required Qty: 1.00

AN8C21A

Purchased

No

250

Each

89.0000

2

2

**

AN8C21A

BOLT

11/21/295

Location

Loc Qty

Loc Code

ST343

89

118758

3

121067

16

121167

20

121275

50

NAS1515H3L

Purchased

No

230

Each

134.0000

4

4

**

*NAS1515H3I *

WASHER

4 (20) 12/03/14

Location

Loc Qty

Loc Code

FG

121556

40

102472

40

ST277

94

118686

3

119438

1

120360

40

121243

50

D2741

Manufactured

No

250

Each

41.0000

1

1

**

D2741

Blade, 350 Skidtube

83130 E SP

Location

Loc Qty

Loc Code

ST

-10

ST466

51

71856

1

76984

2

79516

38

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Page 14

Work Order ID: 83648

Parent Item: D350-636-011

Parent Item Name: Skidtube LH

83648

D350-636-011

Start Date: 23/04/2012

Required Date: 07/05/2012

Start Qty: 1.00

Required Qty: 1.00

D3532-1

Manufactured No

250

Each

29.0000

2

2

D3532-1

Spacer

**

83648

12/4/2012

Location

Loc Qty

Loc Code

ST053

29

78839

5

82041

24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

QTY -041	QTY -042	QTY -043	QTY -044	PART NUMBER	DESCRIPTION
X				D2750-041	350 SKIDTUBE ASSEMBLY, LH
	X			D2750-042	350 SKIDTUBE ASSEMBLY, RH
		X		D2750-043	350 SKIDTUBE ASSEMBLY, LH
			X	D2750-044	350 SKIDTUBE ASSEMBLY, RH
1	1	1	1	D2739	WEB
8	8	8	8	D2743	SPACER
1	1	1	1	D2744	CAP
8	8	8	8	D2745	BUSHING
1				D2750-1	SKIDTUBE WELDMENT, LH
	1			D2750-2	SKIDTUBE WELDMENT, RH
		1		D2750-3	SKIDTUBE WELDMENT, LH
			1	D2750-4	SKIDTUBE WELDMENT, RH
1		1		D3488-041	BLADE FITTING, LH
	1		1	D3488-042	BLADE FITTING, RH
4	4	4	4	D3490-1	SPACER
4	4			D3490-3	SPACER
		4	4	D3490-5	SPACER
8	8	8	8	D3492-041	PLUG ASSEMBLY
8	8			D3492-043	PLUG ASSEMBLY
		8	8	D3492-045	PLUG ASSEMBLY
1	1	1	1	D3535-25	WEARSHOE
1	1	1	1	D3536-25	GASKET
3	3	3	3	D3537-1	WEARPAD
8	8	8	8	D3631-1	WASHER
1	1	1	1	D3791-1	WEARPLATE
1	1	1	1	D3793-1	WEARSHOE
1	1	1	1	D3793-3	WEARSHOE
1	1	1	1	D3794-1	GASKET
1	1	1	1	D3794-3	GASKET
38	38	38	38	ALS4-1032-225	INSERT (OR ALS7-1032-225, AKS4-1032-225, AELS-1032-225)
34	34	34	34	AN3C5A	BOLT
4	4	4	4	AN3C6A	BOLT
4	4	4	4	AN6C44A	BOLT
1	1	1	1	AN8C35A	BOLT
38	38	38	38	AN960C10L	WASHER
1	1	1	1	AN960C816L	WASHER
4	4	4	4	MS21043-5	NUT
1	1	1	1	MS21083C8	NUT
4	4	4	4	NAS1515H3L	WASHER

GENERAL NOTES:

- 1) MATERIAL: MAKE D2750-1/-2/-3/-4 FROM D2600-3 EXTRUSION (INITIAL LENGTH = 120.0).
- 2) FINISH: ACID ETCH, ALONDE ASSEMBLY PER DART QSI 005 4.1 PRIOR TO INSTALLING D2739 WEB.
POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT AS INDICATED TO 1.0 ABOVE SKIDTUBE CENTER-LINE PER DART 005 4.4 (OPTIONAL).
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: D2750-041/-042/-043/-044 = 26.5 LBS
- 8) WELD PER DART QSI 004
- 9) INSTALL ALS4-1032-225 INSERTS AFTER FINISH AS INDICATED. DRILL 'F' SIZE HOLES ($\phi 0.297$) FOR WEARSHOE INSERTS
- 10) FINAL CONFIGURATION SHOULD HAVE THE FOLLOWING MINIMUM MECHANICAL PROPERTIES:
MINIMUM YIELD TENSILE STRENGTH = 35 KSI
MINIMUM ULTIMATE TENSILE STRENGTH = 38 KSI
- 11) SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH AND AFTER INSTALLATION OF INSERTS.
COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY. CLEAN EXCESS OFF
POWDER COATING WITH MEK DEGREASER.
- 12) SPACER AND PLUG INSTALLED SAME AS SECTION AJ-AJ EXCEPT HORIZONTAL
- 13) SPACER AND PLUG INSTALLED SAME AS SECTION AP-AP EXCEPT HORIZONTAL

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WITHOUT NOTICE
WORK ORDER

NO. 83648 MLT

12/04/23

RELEASED

F	INCORPORATE DSI 9413; QTY (3) D3537-1 WAS QTY (5) (ZN C8-1); D3791-1/3 REPLACES D3535-13/35 (ZN C8-1); D3794-1/3 REPLACES D3536-13/35 (ZN B8-1); ADD D3791-1 (ZN C8-1); WEARSHOE HOLES UNDER FWD/AFT SADDLE REMOVED (8 PL). WEARSHOE HARDWARE QTY UPDATED (ZN B8-1); D3488-041/-042 HARDWARE UPDATED (ZN C1-8, 9, 10, 11); ADD NOTE 12 AND 13 (ZN A6-1); REASON: REF. NCR 08-043	PH	08.07.16
E	CHANGE TO STAINLESS STEEL WEARPLATES; ADD RUBBER GASKETS, CHANGE INSERTS; ADD D3631-1; REMOVE QTY (38) NAS1515H3L; REMOVE QTY (10) NAS1515H8L; REMOVE D2741; QTY (2) AN960C816; REMOVE QTY (2) MS21083C8	CB	07.05.17
D	ADD HOLES AND SPACERS FOR APICAL FLOATS; INCORPORATE DEO 9133/9157	PH	06.01.05
C	ADD D2750-3/D2750-4; INCORPORATE D2738 AND D2740	CP	98.11.18
B	CHANGE MS24694-S293 TO AN8-16A	CP	98.09.01
A	NEW ISSUE	DS	98.04.16
REV.	DESCRIPTION	BY	DATE
DESIGN	PC	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
DRAWN	RAH		
CHECKED	ALB	DRAWING NO.	REV. F
MFG. APPR.	ALB	D2750	SHEET 1 OF 11
APPROVED	ALB	TITLE	SCALE
DE APPR.	ALB	350 SKIDTUBE ASSEMBLY	NTS
DATE	08.07.16	COPYRIGHT © 1988 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

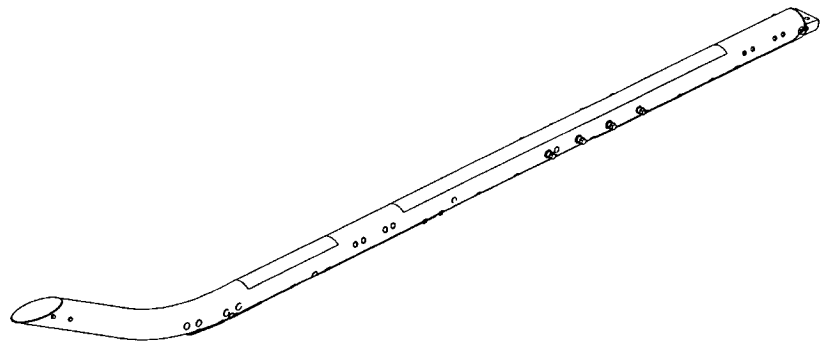
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

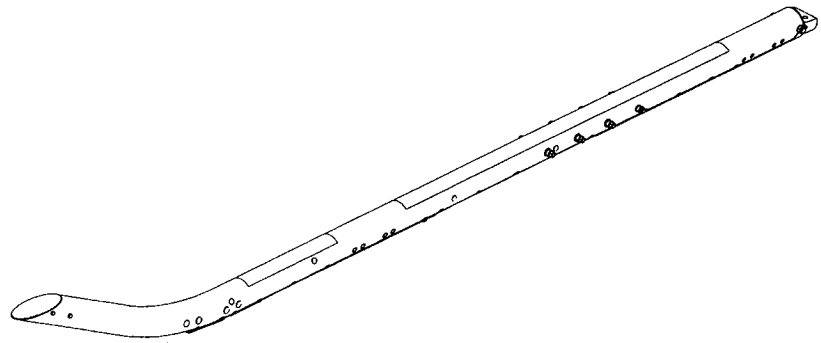
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

83648



D2750-041 350 SKIDTUBE ASSEMBLY, LH



D2750-042 350 SKIDTUBE ASSEMBLY, RH

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08-22-14

DESIGN	PC	DART AEROSPACE USA, INC.	
DRAWN	AD	PORT HADLOCK, WA	
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MFG. APPR.	SA	D2750	SHEET 2 OF 11
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DE APPR.	ST	350 SKIDTUBE ASSEMBLY	NTS
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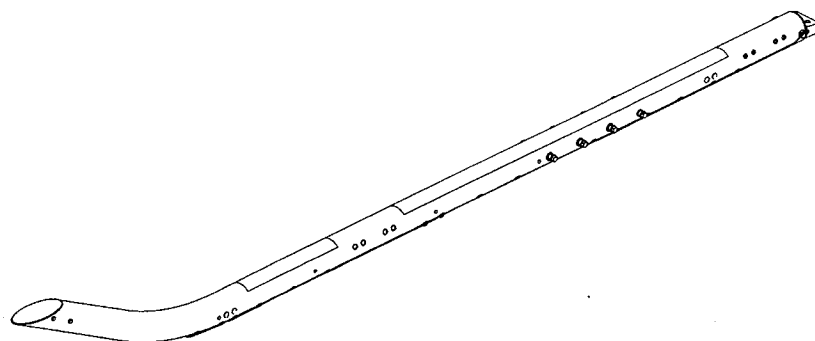
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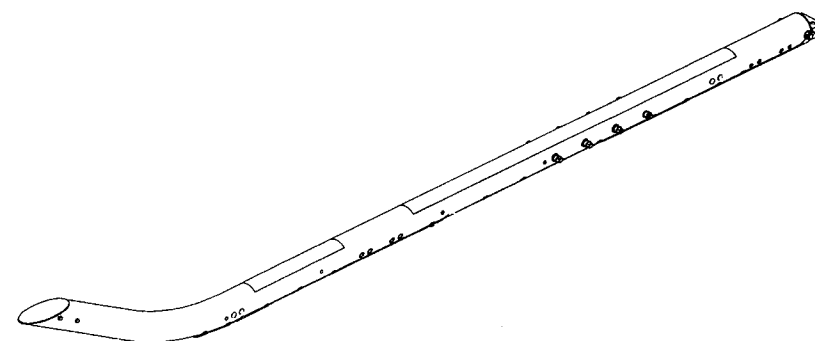
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

83648



D2750-043 350 SKIDTUBE ASSEMBLY, LH



D2750-044 350 SKIDTUBE ASSEMBLY, RH

RELEASED
68-9-22/11

DESIGN	PD	DART AEROSPACE USA, INC.	
DRAWN	PD	PORT HADLOCK, WA	
CHECKED	J	DRAWING NO.	REV. F
MFG. APPR.	NA	D2750	SHEET 3 OF 11
APPROVED	NA	TITLE	SCALE
DE APPR.	NA	350 SKIDTUBE ASSEMBLY	NTS
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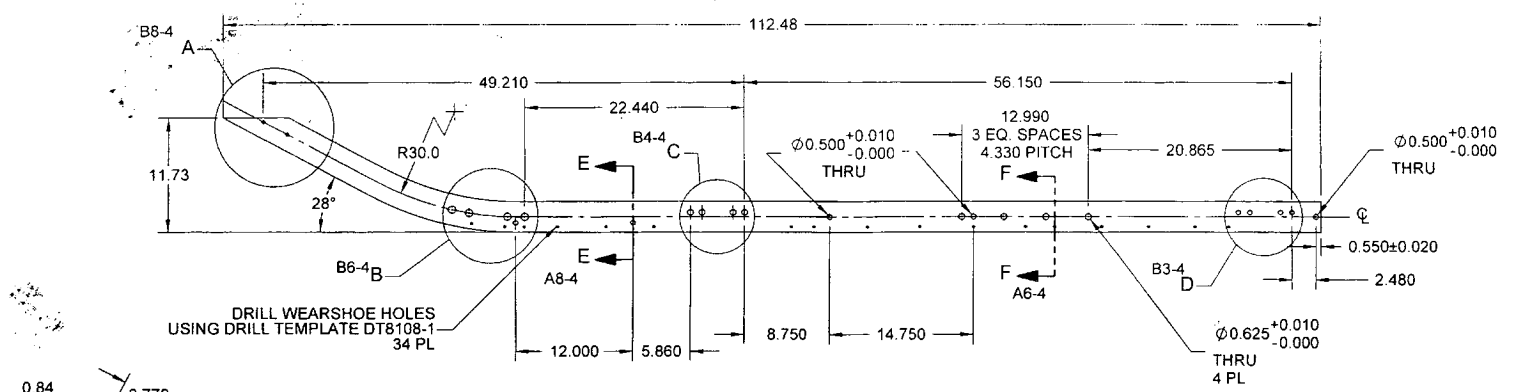
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NOTE: Date & initial all entries

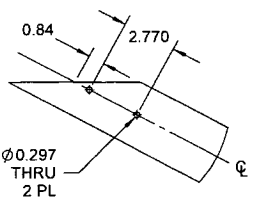
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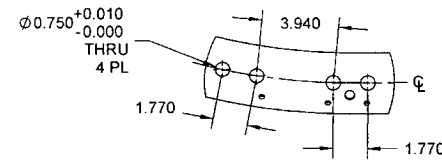
D2750-1 LH SKIDTUBE

83648

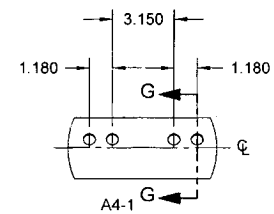
✓
(F)



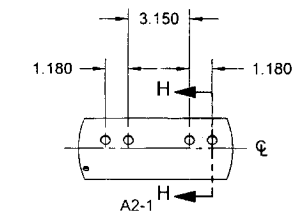
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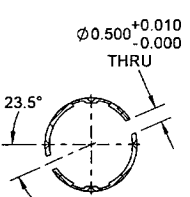
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SCALE 2X



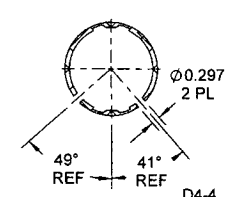
DETAIL C
SCALE 2X



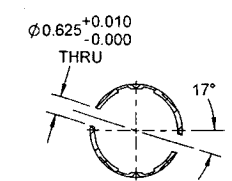
DETAIL D
SCALE 2X



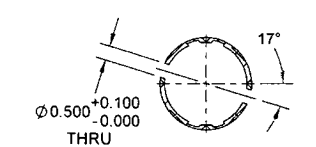
SECTION E-E
SCALE 3X, 2 PL



SECTION F-F
SCALE 3X, 17 PL



SECTION G-G
SCALE 3X, 4 PL



SECTION H-H
SCALE 3X, 4 PL

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08-07-16

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MFG. APPR.			SHEET 4 OF 11
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DE APPR.			NTS
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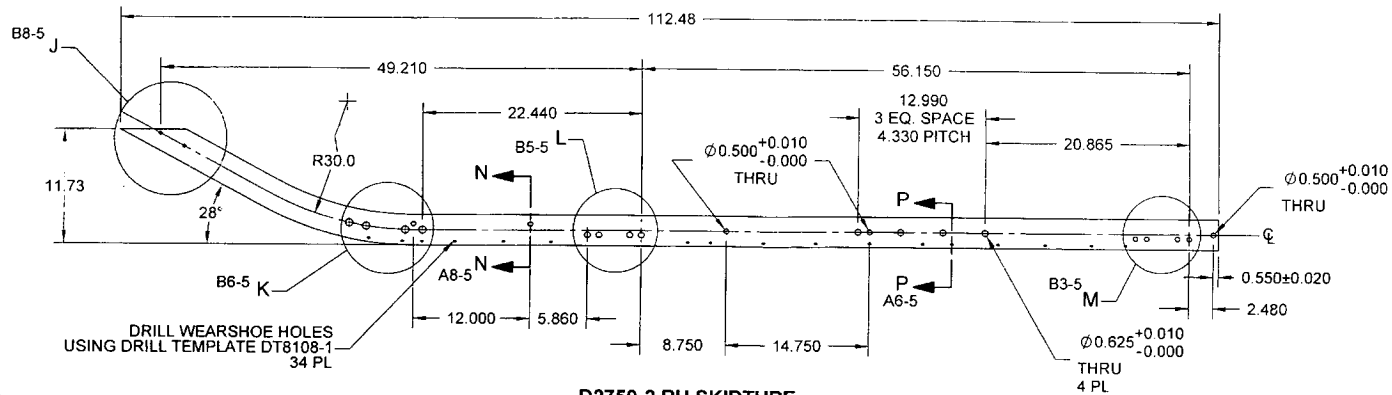
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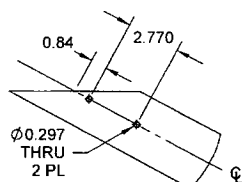
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

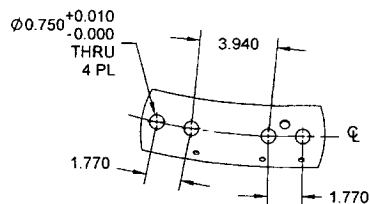
NOTE: Date & initial all entries



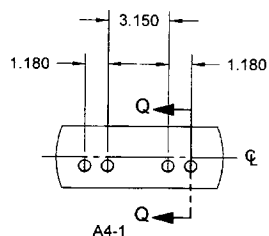
D2750-2 RH SKIDTUBE



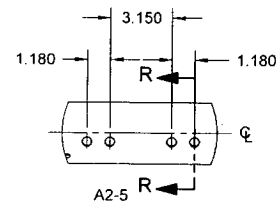
DETAIL J
SCALE 2X



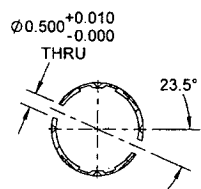
DETAIL K
SCALE 2X



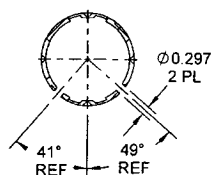
DETAIL L
SCALE 2X



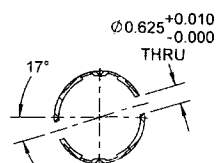
DETAIL M
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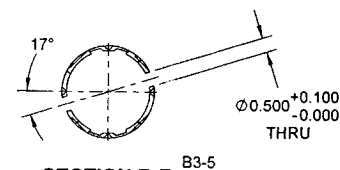
SECTION N-N
SCALE 3X, 2 PL



SECTION P-P
SCALE 3X, 17 PL



SECTION Q-Q
SCALE 3X, 4 PL



SECTION R-R
SCALE 3X, 4 PL

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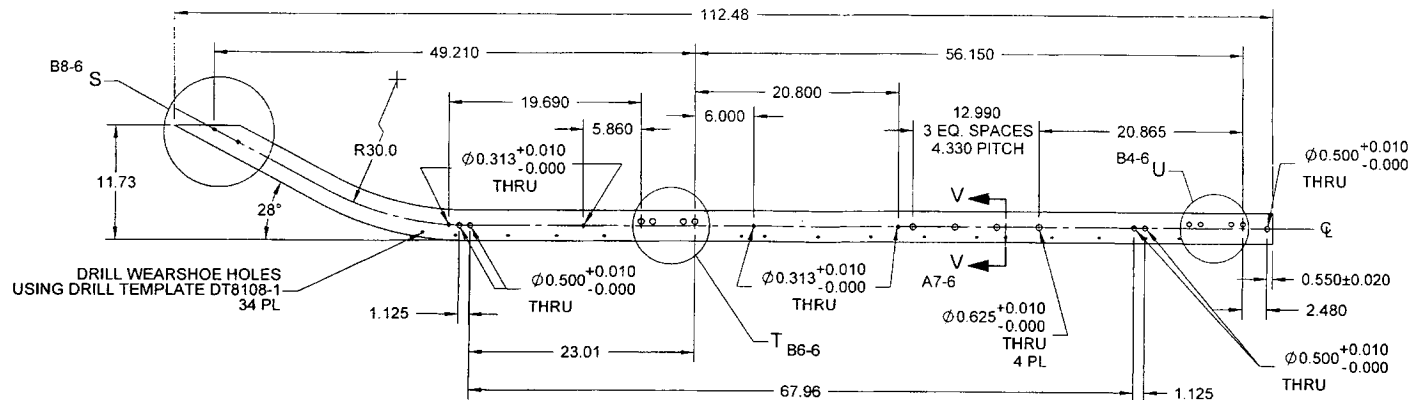
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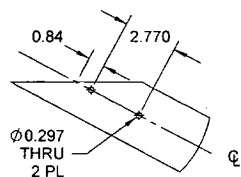
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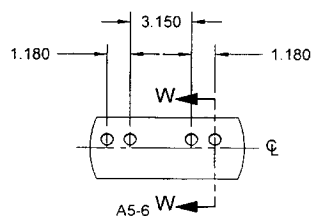
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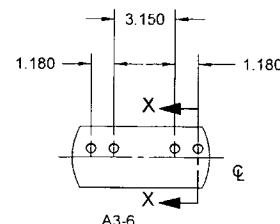
D2750-3 LH SKIDTUBE



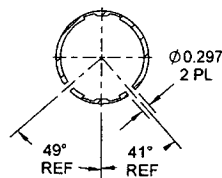
DETAIL S
SCALE 2X



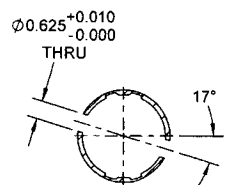
DETAIL T
SCALE 2X



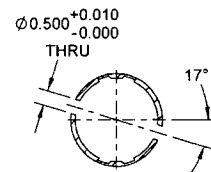
DETAIL U
SCALE 2X



SECTION V-V
SCALE 3X, 17 PL



SECTION W-W
SCALE 3X, 4 PL



SECTION X-X
SCALE 3X, 4 PL

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DESIGN		DART AEROSPACE USA, INC.	
DRAWN		PORT HADLOCK, WA	
CHECKED		DRAWING NO. D2750	REV. F
MFG. APPR.			SHEET 6 OF 11
APPROVED		TITLE	SCALE
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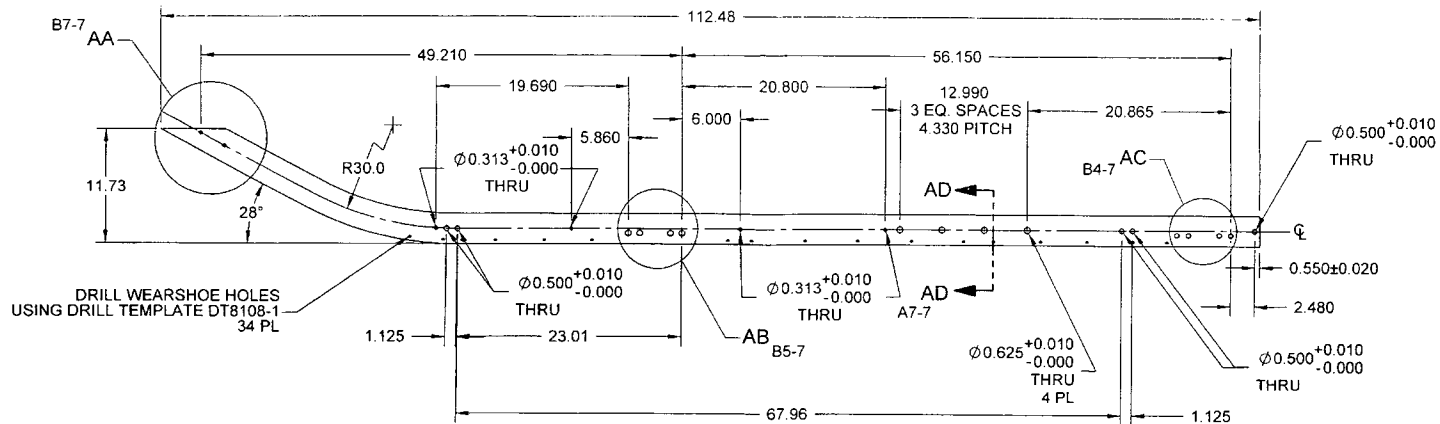
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

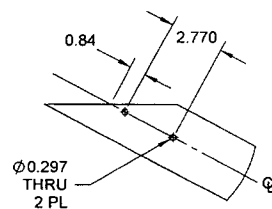
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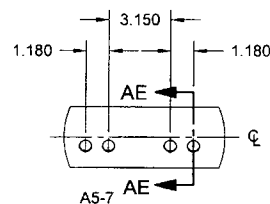
NOTE: Date & initial all entries



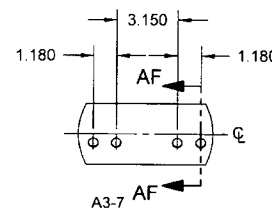
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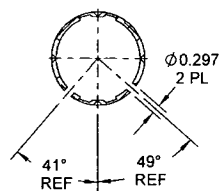
DETAIL AA
SCALE 2X
D7-7



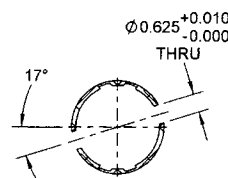
DETAIL AB
SCALE 2X
C4-7
A5-7



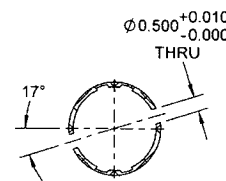
DETAIL AC
SCALE 2X
D3-7
A3-7



SECTION AD-AD
SCALE 3X, 17 PL
D3-7



SECTION AE-AE
SCALE 3X, 4 PL
B6-7



SECTION AF-AF
SCALE 3X, 4 PL
B4-7

RELEASED
08-04-22-118

DESIGN	<i>PA</i>	DART AEROSPACE USA, INC.	
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CHECKED	<i>PA</i>	DRAWING NO.	REV. F
MFG. APPR.	<i>PA</i>	D2750	SHEET 7 OF 11
APPROVED	<i>PA</i>	TITLE	SCALE
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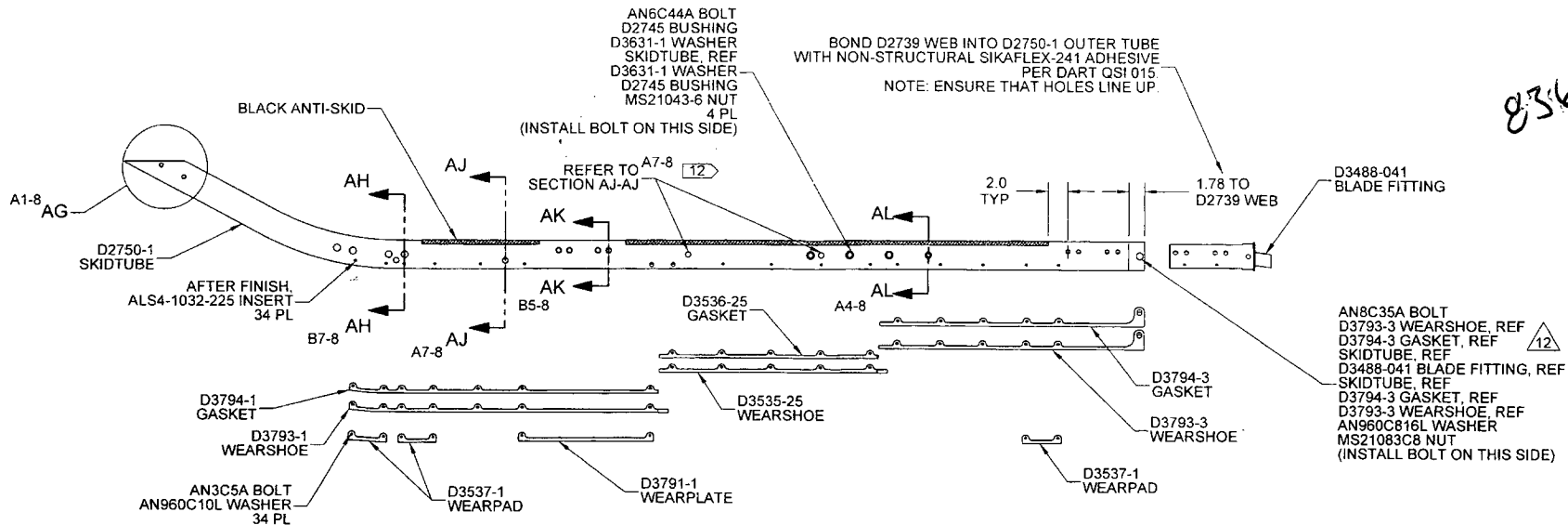
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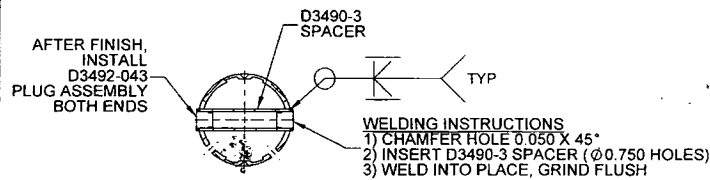
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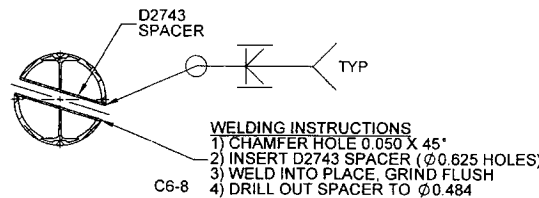
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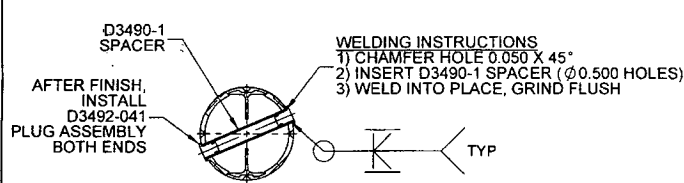
D2750-041 350 SKIDTUBE ASSEMBLY, LH



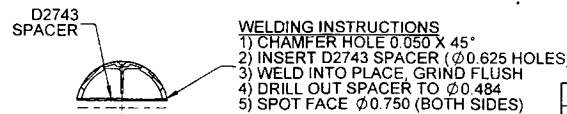
**SECTION AH-AH
SCALE 3X, 4 PL**



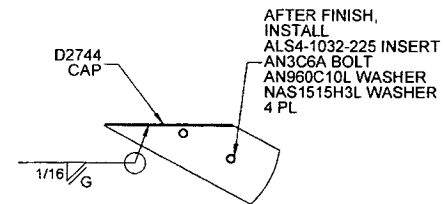
**SECTION AK-AK
SCALE 3X, 4 PL**



**SECTION AJ-AJ
SCALE 3X, 4 PL**



**SECTION AL-AL
SCALE 3X, 4 PL
(HARDWARE REMOVED FOR CLARITY)**



**DETAIL AG
SCALE 2X**

DESIGN	PH	DART AEROSPACE USA, INC.	
DRAWN	PH	PORT HADLOCK, WA	
CHECKED	PH	DRAWING NO.	REV. F
MFG. APPR.	PH	D2750	SHEET 8 OF 11
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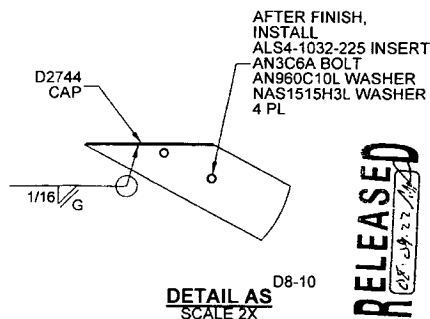
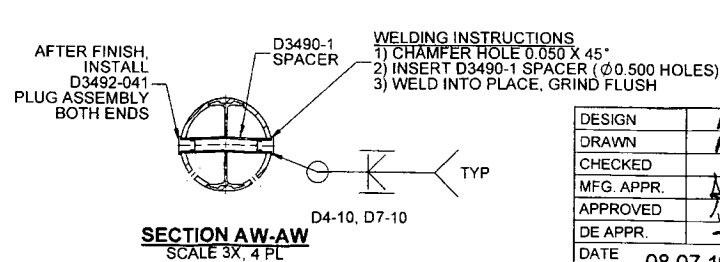
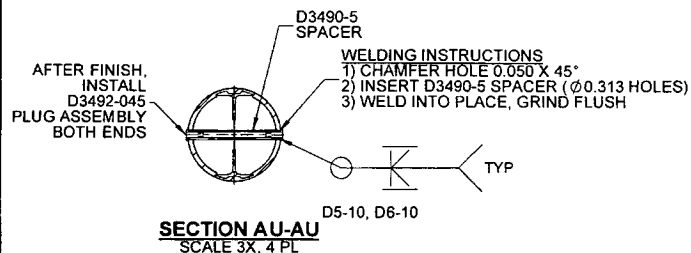
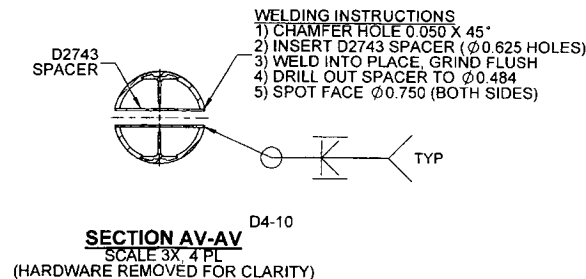
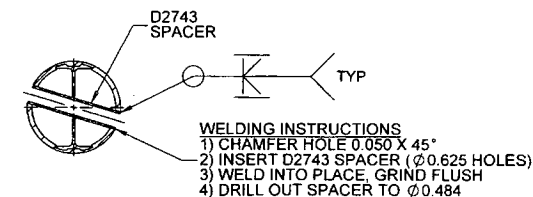
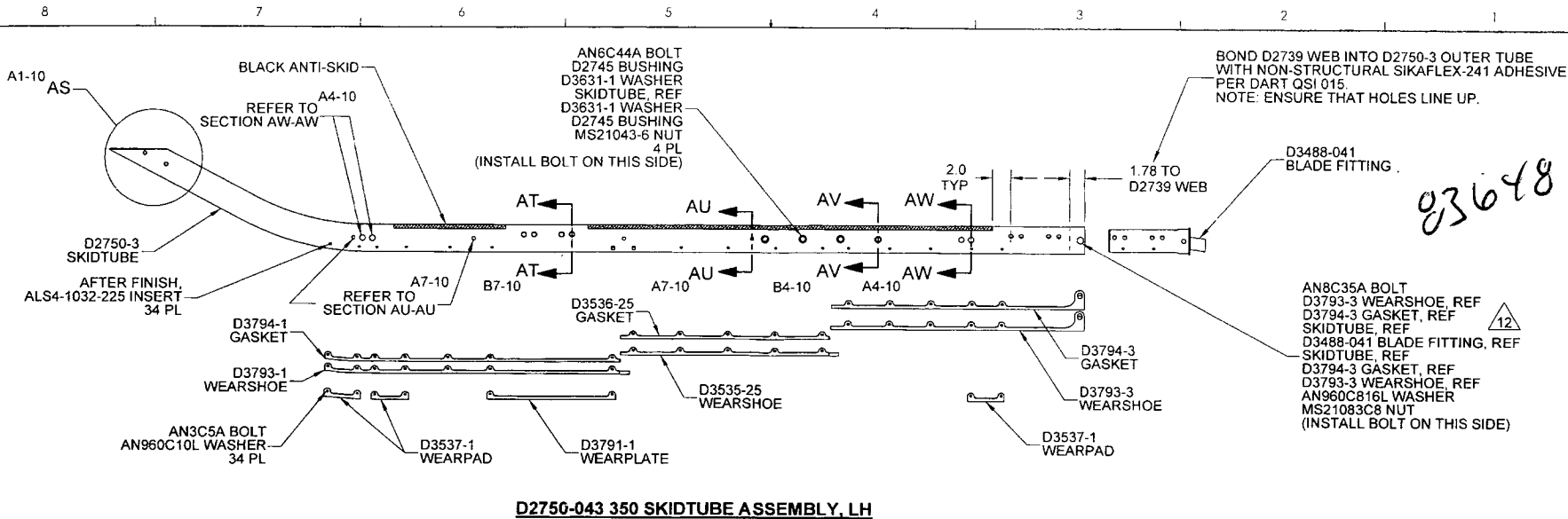
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN	HA	DART AEROSPACE USA, INC.	
DRAWN	HA	PORT HADLOCK, WA	
CHECKED	HA	DRAWING NO.	REV. F
MFG. APPR.	HA	D2750	SHEET 10 OF 11
APPROVED	HA	TITLE	SCALE
DE APPR.	HA	350 SKIDTUBE ASSEMBLY	NTS
DATE	08.07.16	COPYRIGHT © 1998 BY DART AEROSPACE USA, INC.	
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RELEASED
C18-27-1/10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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W/O:		WORK ORDER CHANGES					
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

• NOTE: Date & initial all entries

NO. 293

AWS D17.1.2001
QUALIFICATION TEST RECORD

Name: Barclay Elliott
Job number: 82796
Part number: A350-636-014
Description: Skid tube
Welding Process: Tig[☒] Mig[]
Base material: Alum
Current: AC[☒] DC[]

TEST REQUIREMENTS AND RESULTS

Visual:

pass[☒] fail[]

Penetration:

pass[☒] fail[]

UNACCEPTABLE

Cracks:

pass[☒] fail[]

Undercut:

pass[☒] fail[]

Pin holes:

pass[☒] fail[]

Overlap (cold lap)

pass[☒] fail[]

Porosity (surface):

pass[☒] fail[]

Coloration:

pass[☒] fail[]

Qualifier David Reed Date of Test Coupon 12-05-01
Welder Barclay Elliott Date of Test Coupon 12-05-01

The above named individual is qualified in accordance with AWS D17.1.2001 to weld

